

Oct. 12

Work Order ID 62306



Page 1

Friday, September 24, 2010 3:33:02 PM

Item ID: D4108-049

Accept



Setup Start



Revision ID:

Stop



Item Name: Litter Door Fitting Assembly

Start Date: 9/27/2010 Start Qty: 2.00



Cust Item ID:

Required Date: 10/4/2010 Req'd Qty: 2.00



Customer:

Reference:

Approvals:

Process Plan: *MP*Date: *10-9-24*

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4108

A

100

Pick Kit

0.00



Packaging

Memo

0.00

Packaging

EB 10/10/19 (2)

110

0.00



Small Fab

Memo

0.00

Small Fab

ASSEMBLE AS PER DWG

EB 10/10/19 (2)

120

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

2 10/10/19

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 62306

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Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start



QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130



Packaging

Packaging

Identify as per dwg & Stock Location: 130

0.00

Memo

0.00

140



QC

Quality Control

QC21- Final Inspection - Work Order Release

0.00

Memo

0.00

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Picklist Print

Friday, September 24, 2010 3:33:02 PM

Page 1
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Work Order ID: 62306

Parent Item: D4108-049

Parent Item Name: Litter Door Fitting Assembly





Start Date: 9/27/2010

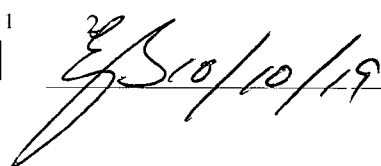
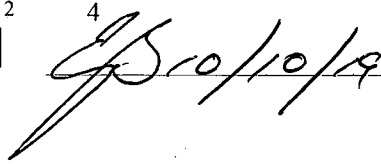
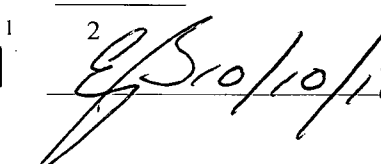
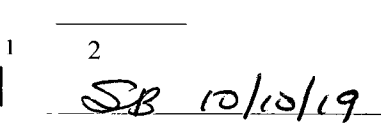
Required Date: 10/4/2010

Start Qty: 2.00

Required Qty: 2.00

Comments: IPP REV:A NEW ISSUE 10-09-24 JLM VERIFIED BY:DD

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3622-1  Ball Stud		Manufactured	No			100	Each	6.0000	1				
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST074		6							
					59915	6							
NAS1149C0532R  WASHER		Purchased	No			100	Each	144.0000	2	4			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST297		144							
					114348	44							
					115531	100							
MS21043-5  Nut		Purchased	No			100	Each	584.0000	1	2			
				<u>Location</u>		<u>Loc Qty</u>		<u>Loc Code</u>					
				ST301		584							
					111819	84							
					112314	500							
D4108-9  Fitting, Litter Door		Manufactured	No			100	Each	0.0000	1	2			
				B 4108-9 B 62843									


2

4

2
 SB 10/10/19 (2)

W/O:		WORK ORDER CHANGES					
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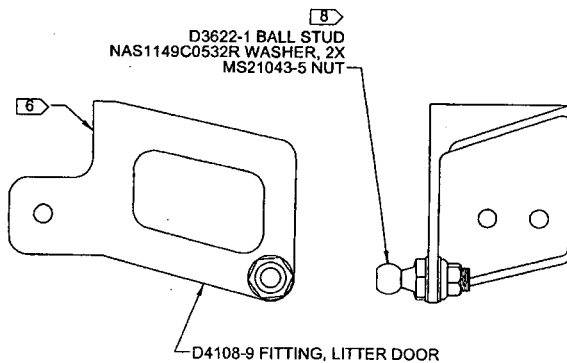
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

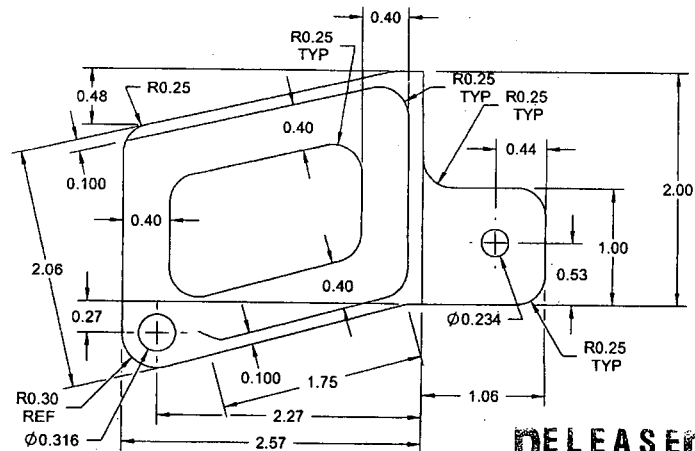
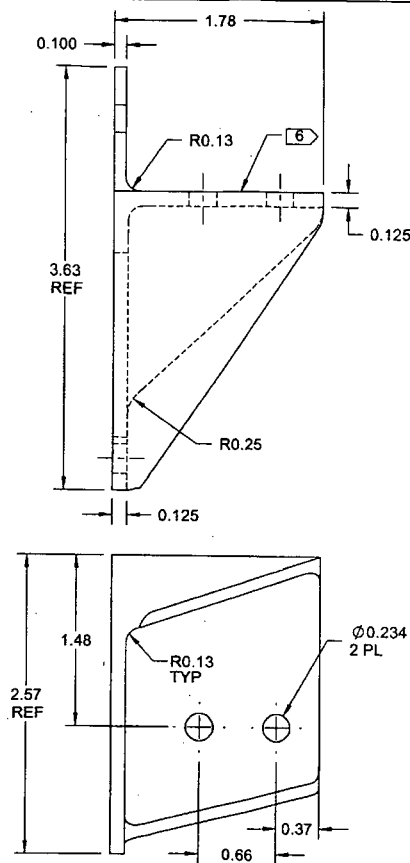
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NOTE: Date & initial all entries

Qty -049	Part Number	Description
	D4108-049	LITTER DOOR FITTING ASSEMBLY
1	D4108-9	FITTING, LITTER DOOR
1	D3622-1	BALL STUD
1	MS21043-5	NUT
2	NAS1149C0532R	WASHER



D4108-049 LITTER DOOR FITTING ASSEMBLY



D4108-9 FITTING, LITTER DOOR

NOTES:

- 1) MATERIAL -9: 303/304/316 STAINLESS STEEL BAR, PER ASTM A276 OR ASTM A582 PER DART SPEC M303B OR M304B
- 2) FINISH: NONE.
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED.
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENT P/N D4108-X & B/N PER QSI 044 6.1
- 7) WEIGHT -049: 0.44 lbs
- 8) TORQUE TO 15 INCH POUND.

DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4108	SHEET 6 OF 7
APPROVED		TITLE	SCALE
DE APPR.		DOUBLERS & FITTINGS	NTS
DATE	10.07.20	COPYRIGHT © 2010 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

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2010-09-23

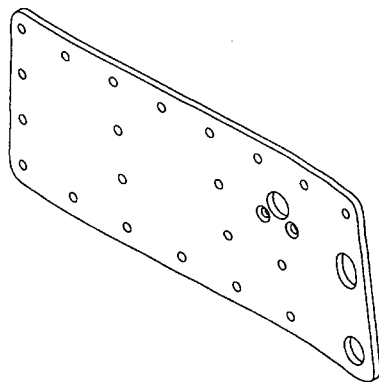
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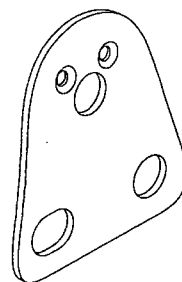
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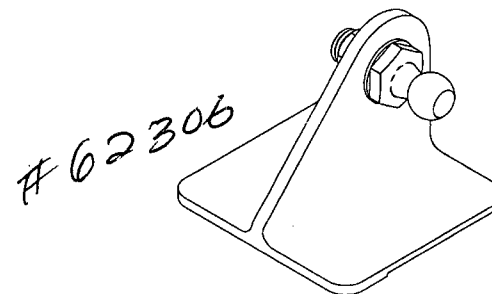
NOTE: Date & initial all entries



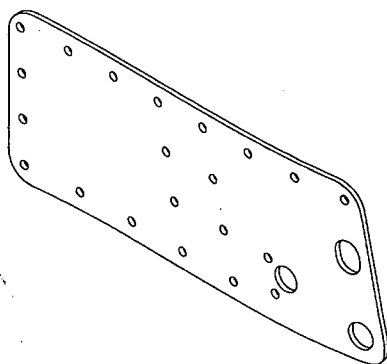
D4108-1 LEFT PASS DOOR DOUBLER



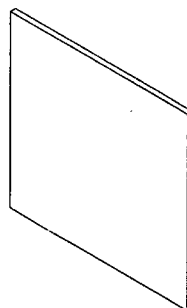
D4108-5 SMALL RIGHT DOOR DOUBLER



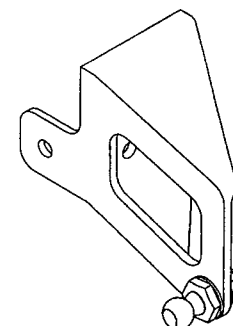
D4108-047 SILL BRACKET ASSEMBLY



D4108-3 RIGHT PASS DOOR DOUBLER



D4108-11 TEMPLATE



D4108-049 LITTER DOOR FITTING ASSEMBLY

RELEASED
2010-09-23
JM

A	NEW ISSUE	JPH	10.07.20
REV.	DESCRIPTION	BY	DATE
DESIGN	JPH	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	JPH		
CHECKED	JPH	DRAWING NO.	REV. A
MFG. APPR.	JPH	D4108	SHEET 1 OF 7
APPROVED	JPH	TITLE	SCALE
DE APPR.	JPH	DOUBLERS & FITTINGS	NTS
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